

Date: Wednesday, 30/07/2008 5:28:00 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT FACING SEAT, LH		
Job Number	: 40808		Part Number	: D412769041		
Estimate Number	: 13462		Drawing Number	: IIN412-769 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 30/07/2008	S.O. No.	:	Drawing Revision	: B	
Prsh Rev.	: NC		Material	:		
First Issue	: //	Type	: SMALL /MED FAB	Due Date	: 22/08/2008	Qty:
Previous Run	: 40574		Um:	: Each		
Written By	:		Comment	: Est rev A 08-07-17 new issue DD verified by:EC		
Checked & Approved By	: JUL 08.7.31					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D412-769-041 CHG 001	N/A KJ
2.0	D412769043	Aft Facing Seat Assembly, LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Aft Facing Seat Assembly, LH batch: 40820	8/8/22 S4
3.0	D412724041	Head Rest Assembly, Center	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Head Rest Assembly, Center batch: 38954	Scd
4.0	D412724043	Head Rest Assembly, LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Head Rest Assembly, LH batch: 38957	8/8/19 S6
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
		Comment: INSPECT 100% KITS FOR COMPLETENESS	8/8/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT FACING SEAT, LH

Job Number: 40808

Part Number: D412769041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



(12)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-769-041

Location: _____

PPP Rev: _____

PPP

40808

8/8/08

SP

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/08 SP

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
	1		D412-769-044	AFT FACING SEAT ASSEMBLY, RH
1	1		D412-724-041	HEAD REST ASSEMBLY, CENTER
1		1	D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

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WORK ORDER
NO. 40808

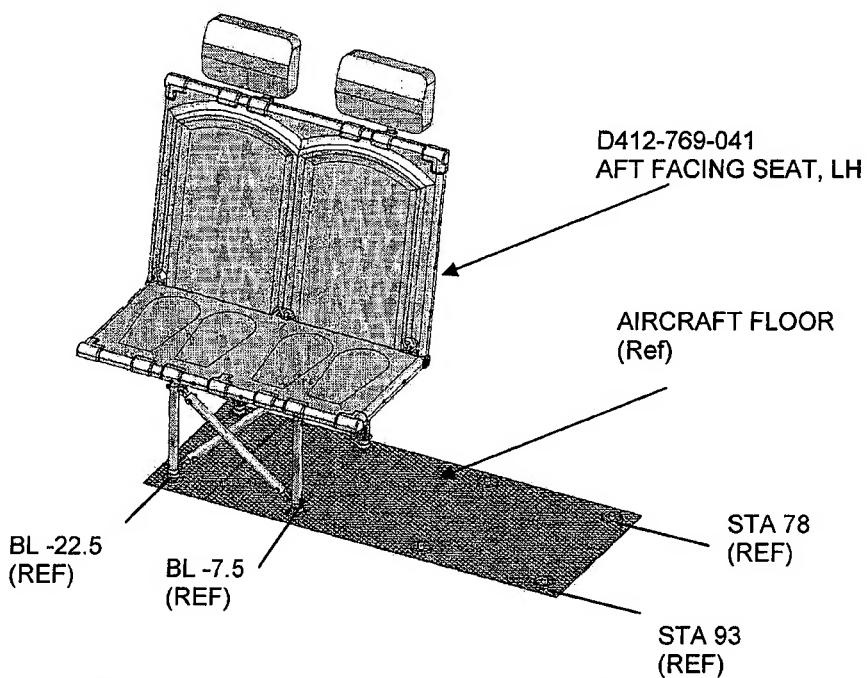


FIGURE 3: D412-769-041 Aft Facing Seat, LH
(LH Installation)

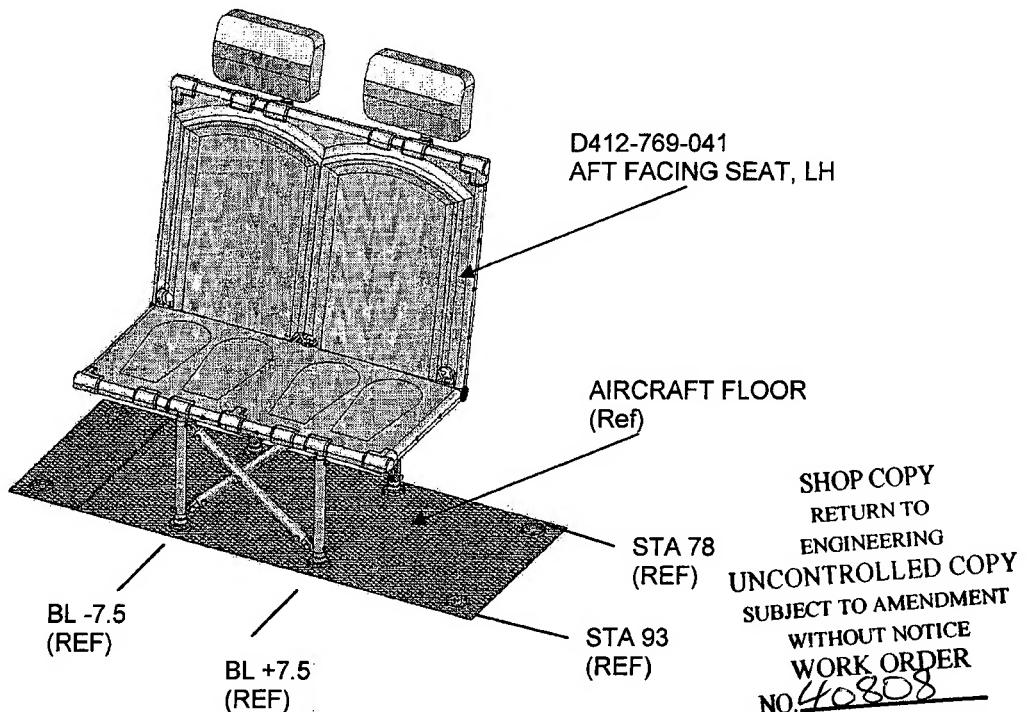
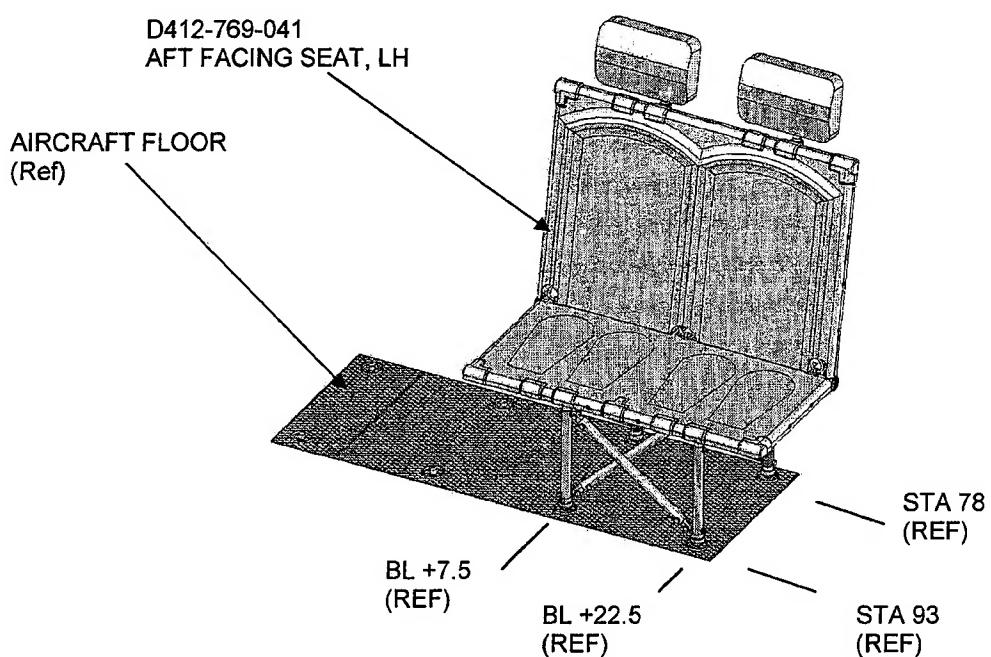


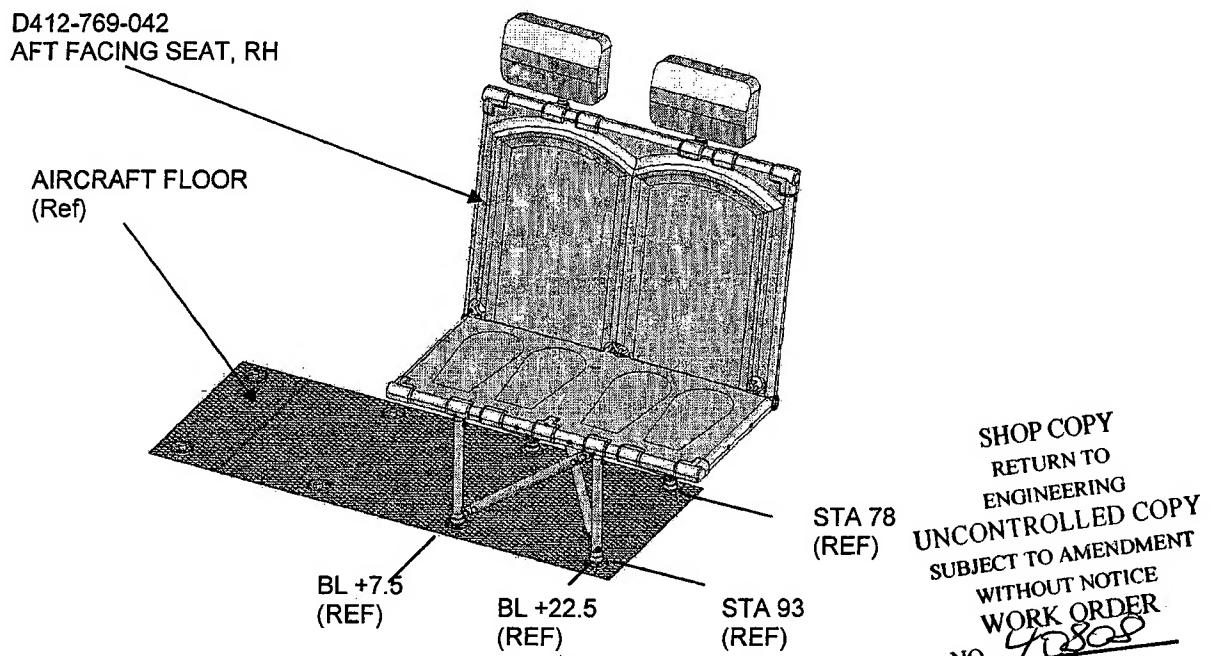
FIGURE 4: D412-769-041 Aft Facing Seat, LH
(Center Installation)

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Revision: **B**
Date: 08.06.24



**FIGURE 5: D412-769-041 Aft Facing Seat, LH
(RH Installation)**



**FIGURE 6: D412-769-042 Aft Facing Seat, RH
(RH Installation)**

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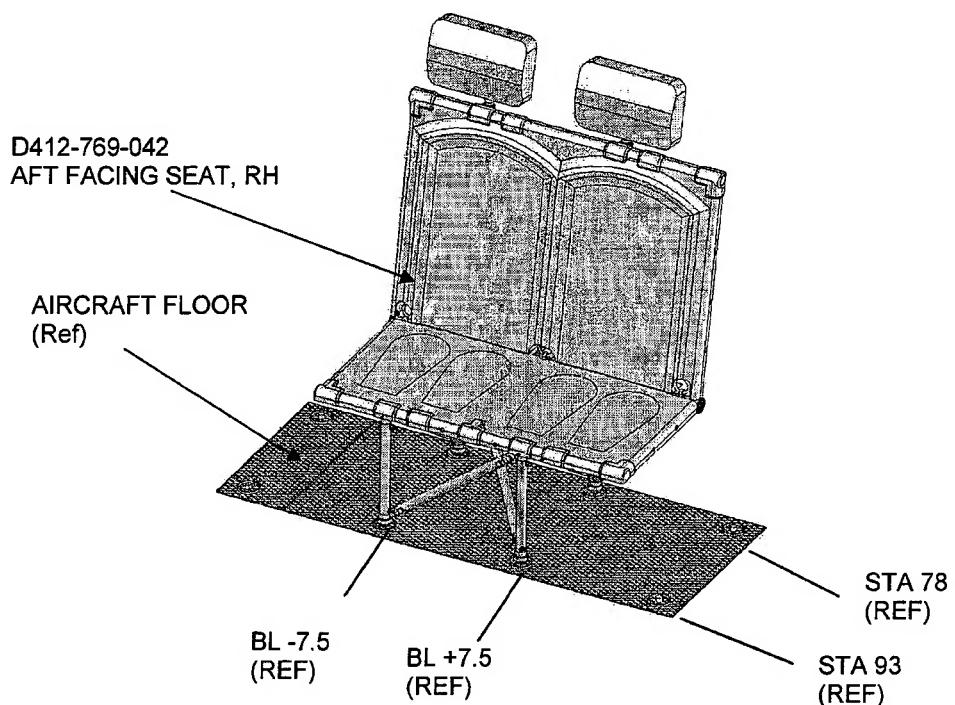


FIGURE 7: D412-769-042 Aft Facing Seat, RH
(Center Installation)

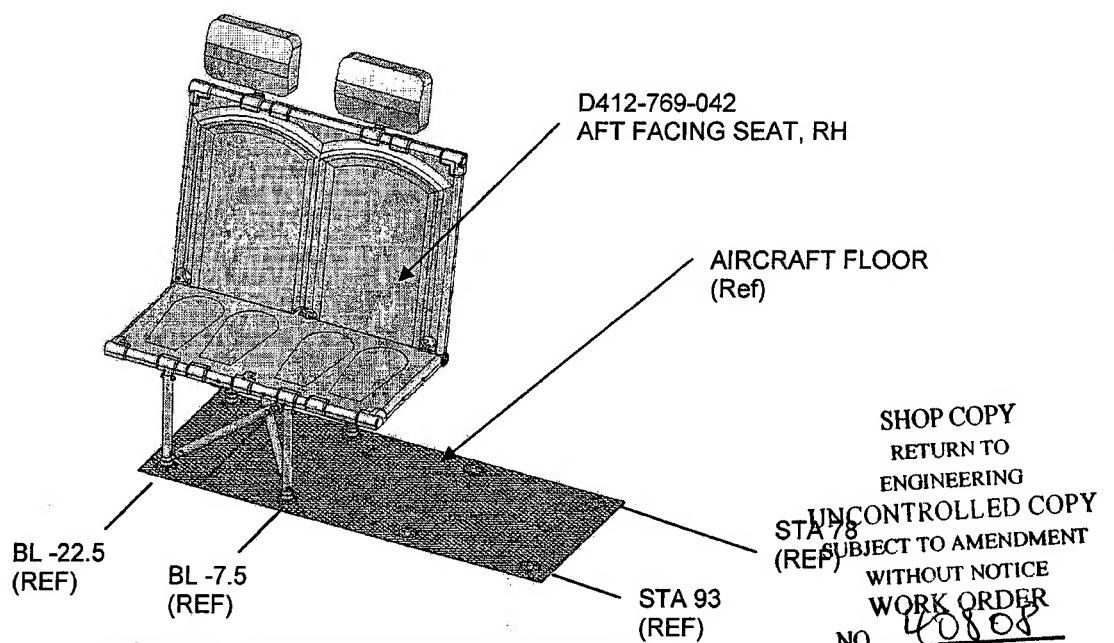


FIGURE 8: D412-769-042 Aft Facing Seat, RH
(LH Installation)

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